

Date: Monday, 6/2/2008 8:36:38 AM
 User: David Duval

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PIN
 Job Number : 05019
 Estimate Number : 13351
 P.O. Number :
 This Issue : 6/2/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D37065
 First Issue : // Type : R&D MACHINED PARTS Drawing Number : D3706 PROTOTYPE
 Previous Run : Project Number : VR0004
 Written By : 08/06/02 Drawing Revision : PROTO 08-05.29
 Checked & Approved By :
 Comment : Est Rev:A New Issue 08-05-30 EC Verified By:DD Material :
 Due Date : 6/9/2008 Qty: 1 Um: Each

Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description :

1.0 M303R0313 303 ROUND BAR



Comment: Qty.: 0.0473 f(s)/Unit Total: 0.0473 f(s)

303 Round Bar 0.313"

Batch: 00500 17106996

08/06/03 ①

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: Doosan Lathe

1- Turn as per Folio FA756 Rev: 08/06/03 & Dwg D3706 Rev: 08/06/03

2-Deburr per dwg D3706

08/06/03 ①

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/06/03 ①

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/06/03 ①

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per dwg D3706

08/06/03 ①

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN

Job Number: 05019

Part Number: D37065

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



060605

**ENGINEERING
APPROVAL**



08.06.03

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING-1

PACKAGING RESOURCE #1



1/1

FOR ENGINEERING USE ONLY



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.04 Prototype

Job Completion



charge to W/O # 00224A

6.1 drill hole as per dwg D3706

08/06/04

①

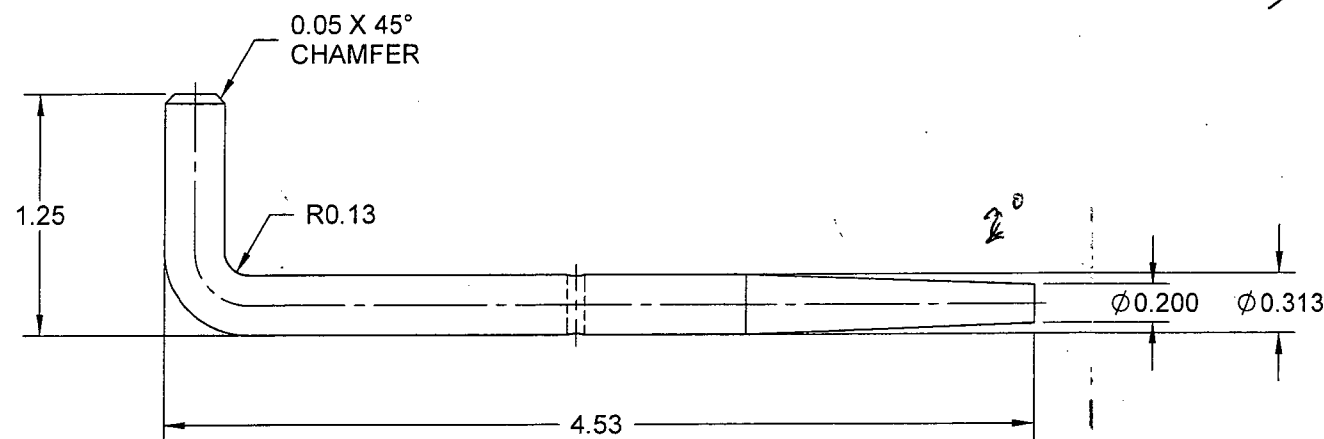
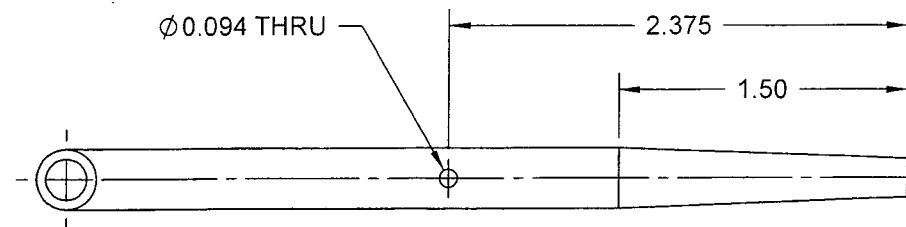
6.2 Qc5

**ENGINEERING
APPROVAL**

060605 ①

08.06.05

mf 08-06-13



D3706-5 PIN

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.05.21

D3706-5 NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
(REF: DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

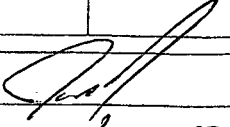


DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG/ APPR.		D3706	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL LOCK	NTS
DATE	08.05.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order:
Description: Crosstube Assembly		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	$\phi 200$	± 0.10	.201	—		
	1.50	± 0.30	1.530	—		
	2.375	± 0.005	2.373	—		
	$\phi .094$	± 0.001	$\phi .099$	✓		
SIDE B						

Measured by: 	Audited by: 	Prototype Approval: N/A 
Date: 02.06.03	Date: 08.06.04	Date: N/A 06.06.05

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Receiving Report

Date: 8/2/01

Batch No: M/06996

Supplier: CAMPI

Dart P/O: 5576

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐
Waybill Attached: Yes ☐ No ☒
Shipment Complete: Yes ☐ No ☒
QC6 Inspection: 08/02/01
Work Order: 11

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M1025720875W125		40	0	0	40	
M606375A0700W063		40	0	0	40	
M304720700W120		20	0	0	20	

M304 526 CA 64 Initials of receiver (if shipment OK) Level 12 92

Production/Admin: 08/02/01
Date: 08/02/01
Received/Costing: 6924
Initial: 69

Location

H:\FORMS\Purchasing\approved purchase\REPORT Rev D

4248
5696

MONTREAL : 514 336-4248
FAX : 514 336-4246

DISTRIBUTEUR D'ACIER ET METAUX SPECIALISES
STEEL AND SPECIALTY METALS DISTRIBUTOR

ONTARIO : 1 800 667-4248
FAX : 1 866 456-4242

On a du Savoir "FER"

HIP TO:

ACE LTD
EN STREET

FACTURE
INVOICE N° 185308

DATE 01/02/08

BON DE LIVRAISON
PACKING SLIP N° 131296

DATE DE LIVRAISON
DELIVERY DATE 01/02/08

TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
NET 30 JOURS	2R		001

DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
1 1/2	56	104.516	CLB	59.54 <u>CL</u>
X 4 20'	69	105.365	CLB	72.87 <u>CL</u>
	9	82.500	CLB	7.52 <u>CL</u>
	14	85.714	CLB	12.63 <u>CL</u>
1/2	56	582.105	CLB	328.81 <u>CL</u>
JA 48 X 96	25	704.000	CLB	176.00
CHARGE	1	2.950	UN	<u>CL</u> 2.95
POIDS TOTAL TOTAL WEIGHT 232				

Formplus N° 8619

ALLS REMAIN THE PROPERTY OF "ACIER CAMPI INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED.
THE BUYER'S EXPENSE. * ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER.
RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY
1 PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. * ANY DEFAULT IN RESPECT WITH
PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE
SOLD. * ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. * ANY MERCHANDISE
T OR MODIFIED CANNOT BE RETURNED. * ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE
CHARGE.

EN BONNE CONDITION / MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y M/M J/D

U CLIENT / CUSTOMER'S SIGNATURE

DATE

SOUS-TOTAL
SUB TOTAL 660.32

T.P.S.
G.S.T. 33.02

T.V.Q.
Q.S.T. 0.00

TOTAL 693.34

(FRI) FEB 1 2008 12:59/ST. 12:57/No. 7523855584 P 5



METALLURGICAL TEST REPORT

NORTH AMERICAN STAINLESS
6870 HIGHWAY 42 EAST
CHENT, KY 41045

NORTH AMERICAN STAINLESS

Certificate: 17437 3 Mail To:

Customer: 007025 005

Ship To:

Date: 1/05/2007 Page: 1

Steel: 303

Finish: CD

Corrosion:

Our Order: C94374

NAS Order: PN 0001427 02

PRODUCT DESCRIPTION:

Round bar, annealed, cold drawn.
ASTM-A-484-00 UNS-S-30300, ASTM A582-95B COND A, Q98-764B COND A,
AMS 5640T TYPE 1, EN 10204 3.1B

REMARKS:

Melted & Manufactured in the USA. Product complies w/ requirements of EU directive 2002.95.EC.RoHS. Material Free from Mercury contamination. No weld repair. NAS certifies the analysis on certification is correct & the material meets specs stated.

Product Id	Diameter	Size	Weight	Length	Mark	Pieces	Commodity Code
BB2768 4	.5000		1,100	144.00	3	1 1	

CHEMICAL ANALYSIS

Heat	CM	C	CO	CR	CU	MN	MO	N	NI	P	S	SI
DXK1	US	.050	.184	17.591	.440	1.822	.366	.045	8.744	.033	.340	.403

MECHANICAL PROPERTIES

Product Id	1 d o i o r	HBHARD HB	YS0.2% KSI	UTS KSI	RA %	EL-4D %	INSTRO n/a
BB2768 4	C L	237.00	97.57	113.01	34.70	21.94	.56

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HESS

1/05/2007